

527

DART AEROSPACE LTD	Work Order:	23570
Description: Outer Saddle	Part Number:	D2919-1
Dwg: D2919 Rev. A1	Qty:	1

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	dkj	05.06.23	1
2	MV	Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950" Material: 6061-T6/T651 (QQ-A-250/11) (D6102-010) Identify as D2919-1			
3	MV	Program batch number	mk	05/06/27	1
4	MV	Machine Step No 1 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	mk	05/06/27	1
5	MV	Machine Step No 2 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	mk	05/06/27	1
6	MV	Machine Step No 3 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	mk	05/06/27	1
7	MV	Machine Keyway and inspect per Dwg D2919 & attached dimension sheet	FJ	05.06.29	1
8	MV	Deburr	RE	05.06.29	1
9	QC2	Inspect parts as they come off the CNC machine	EZ	05.06.29	1
10	QC8	Second inspection	APPROVAL	Q	05.06.30
11	FP	Acid etch and Alodine as per QSI 005 4.1	M	05.07.04	1
12	FP	Powder Coat Gloss White (4.3.5.1) as per Dart QSI 005 4.3	M	05.07.04	1
13	QC3	Inspect Powder Coat	CD	05/07/05	1
14	ST	Identify and Stock	CD	05/07/05	1
15	AC	Cost / part <u>\$ 38.87</u>	SUC	05.07.06	1
16	DC	Close W/O <u>\$ 38.87</u> Inspect Level 21	dkj	05.09.18	1

Rev	Date	Change	Revised By	Approved
A	05.06.23	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature]

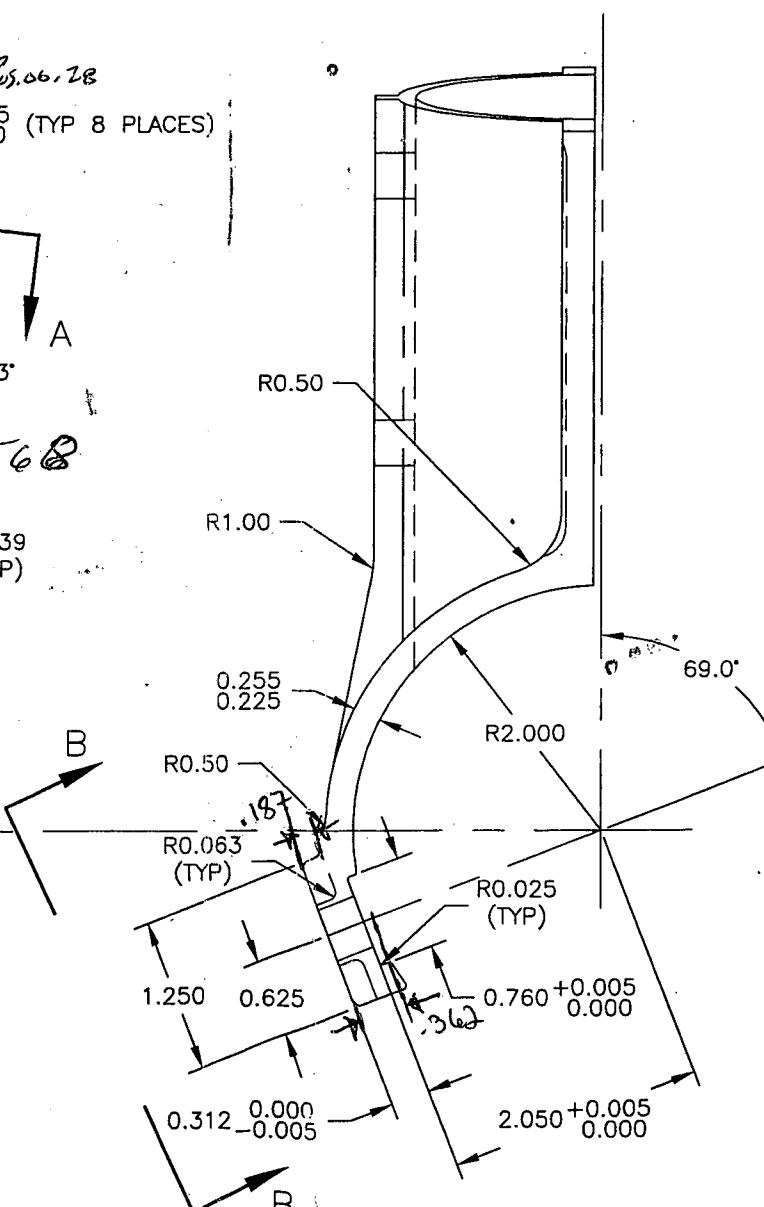
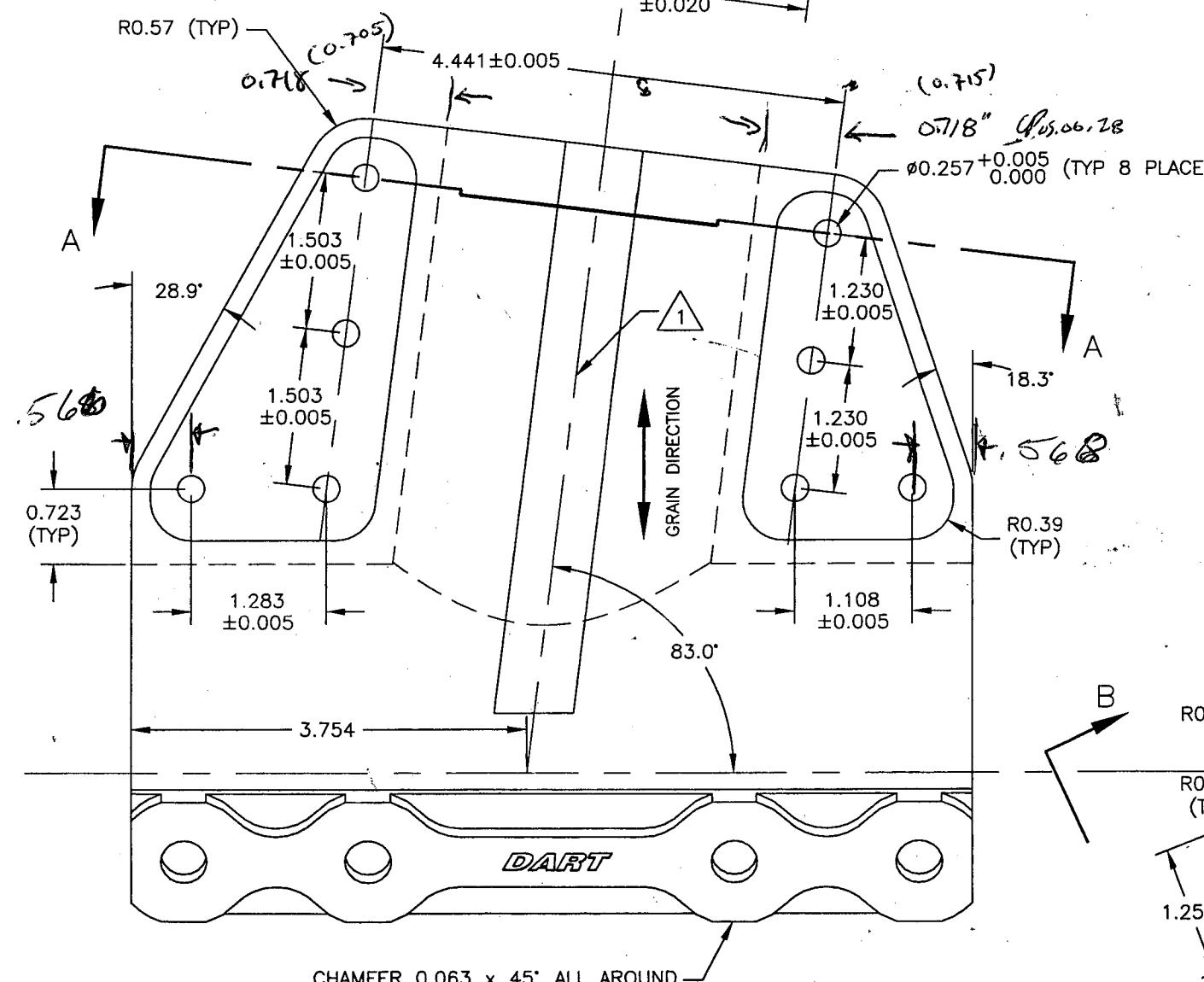
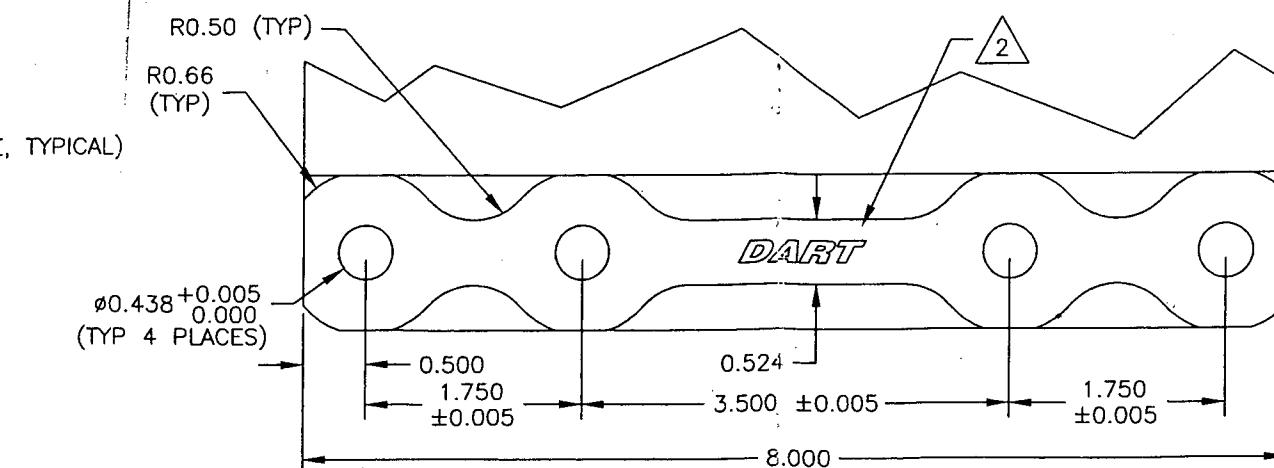
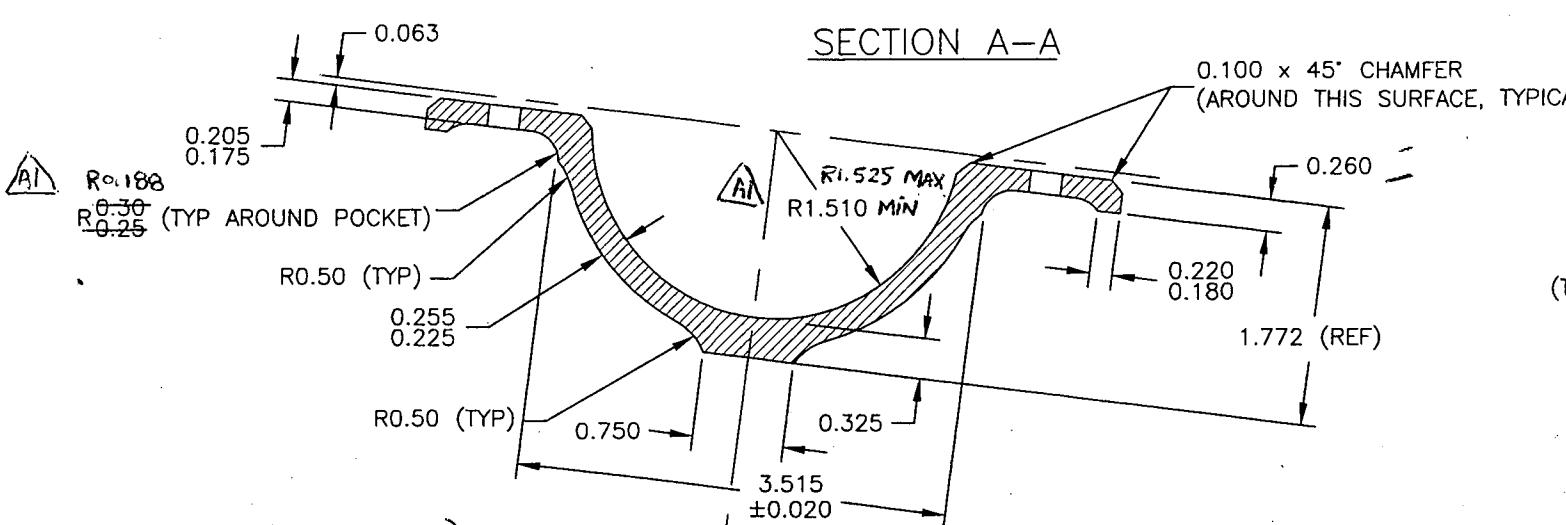
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D2919-1 LH SADDLE (SHOWN) WITHOUT
D2919-2 RH SADDLE (OPPOSITE WORK)

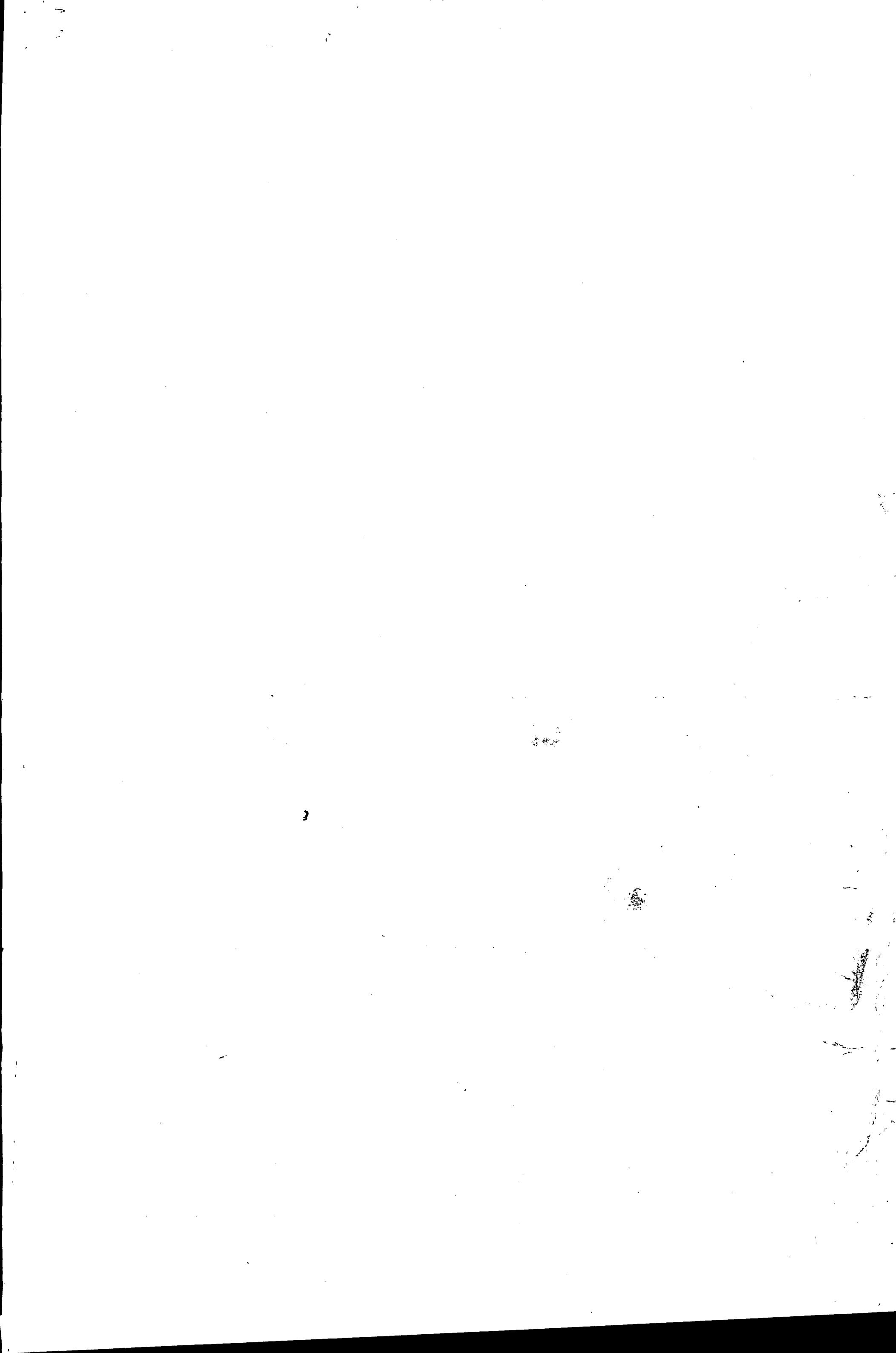
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005
POWDER COAT WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

NO. 2
1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX DEPTH OF 0.010

2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH
MIN RAD 0.125

RELEASE
04.06.25

AI	04.06.13	CHANGE RAD & TOLERANCE
A	04.06.22	NEW ISSUE
DESIGN	DP	DRAWN BY DP
CHECKED	APPROVED	DART AEROSPACE LTD HAWKESBURY
DATE	04.06.22	TITLE OUTER SADDLE



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 16, 2005
08:04 am

Work Order No : 0023570
 Project Name : D2919-1
 Project For : WK527
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2919-1
 Description : Saddle LH
 Manufactured : No
 Amount Req'd : 0
 Amount Done : 0
 Start Date : 06-14-05
 Est Finish Date : 07-04-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

DART AEROSPACE LTD	Work Order:	23570
Description:	Part Number:	D2919-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>BC</u>
Date:	05.06.28

Audited by:	<i>GP</i>
Date:	05.06.34

Prototype Approval: *JP* 05.06.36
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

BARK AEROSPACE LTD

Work Order: 23570

Description:

Part Number: D2919-1

Inspection Date:

Rev:

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FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Design Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.205 / 0.175	N/A	0.195	✓			
1.510 / 1.525	N/A	1.511	—			
0.100" X 45°	±0.01	0.103 X 45°	✓			
0.260	"	0.258	✓			
0.220 / 0.180	N/A	0.215	—			
1.772	±0.01	1.775	✓			
0.325	"	0.328	✓			
3.515	±0.020	3.530	✓			
0.750	±0.01	0.760	✓			
0.255 / 0.225	N/A	0.250	✓			
R 0.188	±0.01	R.188	—			
4.441	±0.005	4.441	✓			
Ø.257	±0.005 -0.000	Ø.258	—			
1.230	±0.005	1.231	✓			
1.230	"	1.229	✓			
1.108	"	1.109	✓			
83°	±0.5°	83°	✓			
1.283	±0.005	1.282	✓			
0.723	±0.01	0.728	✓			
1.503	±0.005	1.503	✓			
1.503	"	1.502	✓			

Measured by: <i>E</i>	Audited by: <i>GP</i>	Prototype Approval: <i>GP</i>
Date: 05.06.28	Date: 05.06.30	Date: 05.06.30

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	